

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021000**Date Inspected:** 20-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Qui Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020BB-073 located on Bottom Plate to Vertical Shear Plate of OBG Segment 14W. ZPMC Welder is identified as 045246. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G-(2F)-FCM-Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2752.

SMAW repair welding of weld joint SEG3020BB-037 located on Bottom Plate to Vertical Shear Plate of OBG Segment 14W. ZPMC Welders are identified as 047864 and 067942. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G-(2F)-FCM-Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2752.

SMAW repair welding of weld joint SEG3020BB-019 located on Bottom Plate to Vertical Shear Plate of OBG Segment 14W. ZPMC Welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G-(2F)-FCM-Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2752.

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Flux Core Arc Welding (FCAW) welding of weld joint SEG3020BB-116 located on Anchor plate to Vertical Shear Plate of OBG Segment 14W. ZPMC Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SEG3020BB-117 located on Anchor plate to Vertical Shear Plate of OBG Segment 14W. ZPMC Welder is identified as 067888. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SEG3020BB-111 located on Anchor plate to Vertical Shear Plate of OBG Segment 14W. ZPMC Welder is identified as 201215. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

SMAW welding of weld joint SEG3020U-588 located on Bottom Plate to Anchor at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 067707. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM.

SMAW welding of weld joint SEG3020R-021 located on Floor Beam to Anchor at panel point 126 of OBG Segment 14W. ZPMC Welders are identified as 067829 and 067765. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2114-Tc-U4b-FCM.

SMAW welding of weld joint SA3174-001-005 located on Sub Assembly Component of OBG Segment 13CW. ZPMC Welder is identified as 067588. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2211-B-U3b.

SMAW welding of weld joint SA3173-001-005 located on Sub Assembly Component of OBG Segment 13CW. ZPMC Welder is identified as 066674. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2211-B-U3b.

Sub Merged Arc (SAW) welding of weld joint SEG3013-006 located on deck panel to deck panel splice weld of OBG Segment 13AW. ZPMC Welder is identified as 045270. ZPMC Quality Control (QC) is identified as Mr. Liu Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

SMAW welding of weld joint DP3172-001-018 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 067520. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint DP3173-001-022 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 037779. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint DP3174-001-019 located on Deck Panel to Deck Panel Diaphragm of OBG

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Segment 14W. ZPMC Welder is identified as 067611. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint DP3174-001-021 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 037780. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

Sub Merged Arc (SAW) welding of weld joint SEG3013-006 located on deck panel to deck panel splice weld of OBG Segment 13AW. ZPMC Welder is identified as 045270. ZPMC Quality Control (QC) is identified as Mr. Liu Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer
